

इंटरनेट

मानक

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“जानने का अधिकार, जीने का अधिकार”

Mazdoor Kisan Shakti Sangathan

“The Right to Information, The Right to Live”

“पुराने को छोड़ नये के तरफ”

Jawaharlal Nehru

“Step Out From the Old to the New”

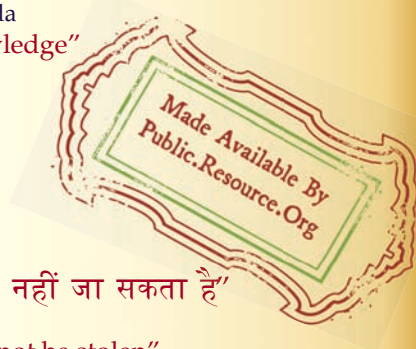
IS 4294 (1982): Jig Buttons [PGD 2: Machine Tool Elements and Holding Devices]



“ज्ञान से एक नये भारत का निर्माण”

Satyanarayan Gangaram Pitroda

“Invent a New India Using Knowledge”



“ज्ञान एक ऐसा खजाना है जो कभी चुराया नहीं जा सकता है”

Bhartrhari—Nitiśatakam

“Knowledge is such a treasure which cannot be stolen”

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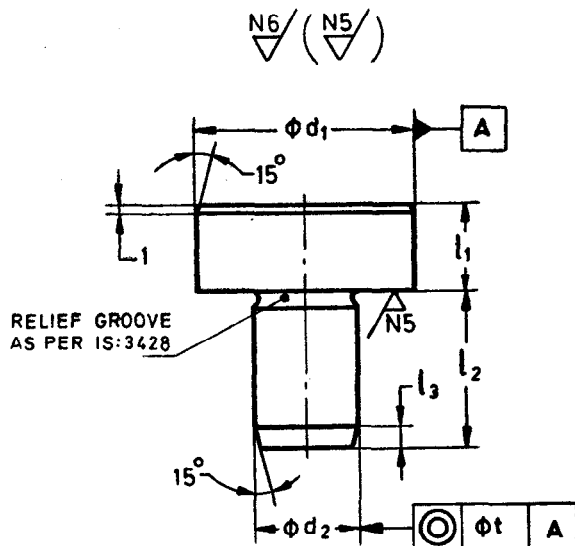


Indian Standard
SPECIFICATION FOR
JIG BUTTONS

(First Revision)

1. **Scope** — Covers the dimensions and material requirements for jig buttons.

2. **Dimensions**



All dimensions in millimetres.

d_1 g6	d_2^* p6	l_1 h9	l_2	l_3	t
6	4	5	6	1.2	0.02
8	6	5	9	1.6	0.02
10	6	6	9	1.6	0.02
12	6	6	9	1.6	0.02
16	8	8	12	2.0	0.04
20	12	8	18	2.5	0.04
25	12	10	18	2.5	0.04

*Corresponding hole; Tolerance H7.

Note — Dimensional deviations for untoleranced dimensions : Medium class according to IS : 2102 (Part 1) - 1980 'General tolerances for dimensions and form and position : Part I General tolerances for linear and angular dimensions (second revision)'.

3. **Material** — Suitable steel hardened to 56 ± 2 HRC.

Adopted 19 February 1982

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Cr. 1

IS : 4294 - 1982

4. Designation — A jig button having $d_1 = 10$ mm and $l_1 = 6$ mm shall be designated as:

Jig Button 10 × 6 IS : 4294

5. Finish — The jig buttons shall be free from cracks, burrs, pits and other defects.

6. Preservation and Packing

6.1 A suitable anti-corrosive surface treatment shall be given to jig buttons.

6.2 The jig buttons shall be packed in suitable cartons so as to prevent damage during transit.

7. Marking — The carton containing jig buttons shall be marked with designation and the manufacturer's name or trade-mark.

7.1 ISI Certification Marking — Details available with the Indian Standards Institution.

EXPLANATORY NOTE

This standard was first published in 1967 and was based on DIN 6321-1958. The present revision has been taken up in order to incorporate the latest manufacturing practices.

Jig buttons are used as rests for work-pieces and workholders. The height l_1 has been toleranced at h9 to obviate the need for equalizing the heights after fitting when two or more of the buttons are used. This type of jig buttons may also be used as a lateral support. In this revision, tolerances g6 and p6 have been assigned to diameters d_1 and d_2 respectively.

Other types of location pins, namely, location pins, cylindrical and flattened, will be included in IS : 5093, 'Dimensions for locating pins (rounds)', and IS : 5094 'Dimensions for diamond locating pins' (being revised).

While preparing this standard, assistance has been derived from DIN 6321-1973 'Support and location pins' issued by Deutsches Institut für Normung (DIN).